Work Order ID 58586

Wednesday, May 12, 2010 8:30:47 AM



Page 1

Item ID:

D3913-15

Accept

Accept

Qty

Setup Start

Stop



Revision ID: Item Name:

Wide Handle Plate

Start Date: 5/12/2010

Start Qty: 3.00 Required Date: 5/14/2010

Req'd Qty: 3.00

Cust Item ID: **Customer:**

Draw

Number

Reference:

Approvals:

Process Plan: MC

Date: 10-5-17 Tooling:

Draw

Rev.

Plan

Code

Run Start



Date: _____ SPC (Y/N):

Date:

Stop

Reject

Qty



Insp.

Stamp

Reject

Number

Sequence ID/ Work Center ID Draw Nbr

Operation Description

Revision Nbr

Α

D3913

100

Waterjet FLOW CNC Waterjet

Memo

Cut as per dwg D3913

Prog Rev: Dwg Rev:

Deburr as required

Run Hours

Set Up/

0.00

0.00

B10-5-12

110

QC2- Inspect parts off machine FAI/FAIB

0.00

1210-5-17

Quality Control

Memo

0.00

Resolution:		Dispositi	on:	QA: N/C Closed:			Date:		
NCR:	NCR:		WORK ORDER NON-CONFORMANCE (NCR)					·····	
		Description of NC		Corrective Action Section	on B	Varifica		A	Annroyal
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verificat Section		Approval Chief Eng	Approval QC Inspector
							— — -	. <u> </u>	
							!		
								_	

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

NOTE: Date & initial all entries

Work Order ID 58586

Wednesday, May 12, 2010 8:30:47 AM



Page 2

Item ID:

D3913-15

Accept

Setup Start

Stop



Item Name: **Start Date:**

Revision ID:

Wide Handle Plate 5/12/2010

Start Qty: 3.00 Req'd Qty: 3.00

Cust Item ID: Customer:

Draw

Number

Reference:

Required Date: 5/14/2010

Approvals:

Process Plan: Date: Tooling:

Date:

Run Start



QC: _____ Date: ____ SPC (Y/N):

Set Up/

Run Hours

Date: _____

Stop

Sequence ID/ Work Center ID

120

Quality Control

Operation Description

QC8- Inspect parts - second check

Memo

Memo

10/05/12

Plan

Code

Draw

Rev.

Accept Reject Qty Qty

Reject Number Stamp

Insp.

Packaging

Packaging

140

Identify as per dwg & Stock Location:____

0.00

0.00

150

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

//19/18B)

10/05/18 A) BP 10-5-18

W/O:			WC	RK ORDER CHANG	ES					
DATE	STEP	PR	OCEDURE CHAI	NGE	Ву		Date	City	Approval Chief Eng / Prod Mgr	Approva QC Inspecto
Part No):	PAR #:	Fault Categ	jory:	_ NCR: Ye	es N	lo DQA:		Date:	
	Reso	lution:	Disposition: QA:			A: N/C Closed: Date:				
NCR:			WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Initial Action Descrip		Section B on Sign &		Verifica		Approval	Approva
		Section A	Chief Eng	Chief Eng		ite	Section		Chief Eng	QC Inspecto
							1			

NOTE: Date & initial all entries

Picklist Print

Wednesday, May 12, 2010 8:30:46 AM

Work Order ID: 58586

Parent Item: D3913-15

Parent Item Name: Wide Handle Plate

Comments:

IPP Rev:A new issue DD 10.03.19 verified by:EC

Start Date: 5/12/2010

Required Date: 5/14/2010

Page 1

Start Oty 3 00

因10-517

Component Item ID/	D .						ì	Start Qty: 3.00		Required Qty: 3.00		
Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
M304S11GA 		Purchased	No			100	sf	62.3800	0.1068			

304/316 0.125 Sheet

Location Loc Oty Loc Code MAT 62.38

114488

114488)

62.38

Dart	Aeros	pace	Ltd

W/O:	1	WORK ORDER CHANGES								
DATE	STEP	PROC	CEDURE CH	IANGE	By Date				Approval Chief Eng / Prod Mgr	Approval QC Inspector
								:		
Part No	:	PAR #:	_ Fault Ca	tegory:	NCR	: Yes N	lo DQA:		Date:	
	R	esolution:	_ Disposit	ion:	_QA:	N/C Clo	sed:		Date:	
NCR:		W	ORK OR	DER NON-CONFORMA	NCE	(NCR)				
DATE	STEP	Description of NC Section A	Initial	Corrective Action Section Action Description	on B	Sign &	Verifica Section		Approval Chief Eng	Approval QC Inspector
			Chief Eng	Chief Eng		Date	Jection		Office Eng	QO IIISPECIOI
	<u> </u>									
				•	,					
NOTE: D	-1- 0 :- :::		_1		. 1					,

NOTE: Date & initial all entries

H:\fORMS\Quality Assurance\approved QA\NCRWO RevE

DART AEROSPACE LTD	Work Order:	28282
Description: WIDE HANDLE PLATE	Part Number:	D3913-15
Inspection Dwg: 739 Byg. Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article X Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
75	4- 630	756	¥			
1.50	4030	1,509	٧.			
3,00	1/2 000	3,005	*			
5.13	4030		Se .			
,13	4 (03)	-118	>			
·						
	-					
					,	
	1					
						· · · · · · · · · · · · · · · · · · ·

			^	
Measured by:	B	Audited by:	9	Prototype Approval:
Date:	10-5-12	Date:	Westia	Date:

Rev	Date	Change	·	Revised by	Approved
Α		New Issue		KJ/JLM	<u> </u>

-- 0.75 --R0.06 TYP 3.00

D3913-15 WIDE HANDLE PLATE

DESIGN DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWN CHECKED DRAWING NO. REV. A D3913 MFG. APPR. SHEET 6 OF 6 APPROVED SCALE LONG BASKET BASE ASSY (350) NTS

COPYRIGHT © 2010 BY DART AEROSPACE LTD

Pel DOMANDY OF PRINT THE COPYRIGHT WHO BE SPALED ON THE COPYRIGHT OF 2010 BY DART AEROSPACE LTD

Pel DOMANDY OF PRINT THE COPYRIGHT ON CONSACRATION OF THE COPYRIGHT OF THE DE APPR. DATE 10.03.16

2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.31 lbs

1.50

8

D

С

5

0.13

3

2

В

Α

NOTES:
1) MATERIAL: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH,
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S11GA

Dail Ac	rospace Ltd						
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date			

DATE	STEP	PROC	PROCEDURE CHANGE					Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
								-		
Part No	:	PAR #:	_ Fault Ca	_ Fault Category: No			lo DQA		Date:	
			_ Disposition: QA			N/C Clo	sed:			
NCR:		W	ORK OR	DER NON-CONFORM	ANCE	(NCR)	<u> </u>			
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section Description Chief Eng	tion B	Sign & Date	Verifica Section	tion C	Approval Chief Eng	Approval QC Inspector
1			Officer Ling	Office Eng		Date				
							:			
	 									

NOTE: Date & initial all entries